

# Work Order ID 78832

**\*78832\***

Page 1

January-16-12 1:31:42 PM

Item ID: D2654-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Web  
 Start Date: 16/01/2012 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 30/01/2012 Req'd Qty: 8.00 **\*8\*** Customer:  
 Reference:

Approvals: Process Plan: M.C.J. Date: 12/01/16 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2654	F

100 Skidtubes 0.00  
**\*100\***  
 Skidtubes Memo 0.00  
 Skidtubes  
 1-Cut D2600-7 to length as per Dwg D2654  
 2-Drill pilot holes in web using drill jig DT 8018-5 as per Dwg D2654  
 3-Using the uni-bit, open holes to finish size as per Dwg D2654  
 4-Deburr holes and ends

110 QC5- Inspect part completeness to step on W/O 0.00  
**\*110\***  
 QC Memo 0.00  
 Quality Control

120 Chemical Conversion Coat per QSI005 4.1 0.00  
**\*120\***  
 HandFinish Memo 0.00  
 Hand Finishing

⑧ CF/B 12-1-16  
 ⑧ CF/B 12-1-17  
 DP 12-1-17 ⑧  
 ⑧ CF/B 12-1-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 78832

**\*78832\***

Page 2

January-16-12 1:31:42 PM

Item ID: D2654-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Web  
 Start Date: 15/01/2012 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 30/01/2012 Req'd Qty: 8.00 **\*8\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
<b>*130*</b>						8		SAD	12-01-17
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
<b>*140*</b>						8		SAD	12-01-17
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
<b>*150*</b>									12/1/18
QC	Memo	0.00							
Quality Control									

12-01-17  
 (8)

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NOTE: Date & initial all entries

# Picklist Print

January-16-12 1:31:49 PM

Page 1

Work Order ID: 78832

\*78832\*

Parent Item: D2654-5

\*D2654-5\*

Parent Item Name: Web

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedureDM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-7-125		Manufactured	No			100	Each	0.0000	1	8			

\*D2600-7-125\*

Extrusion 'I Beam' thick

\*\*

B72279

8

CF

12-1-16

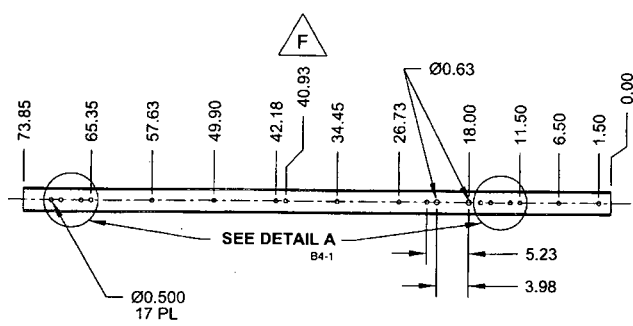
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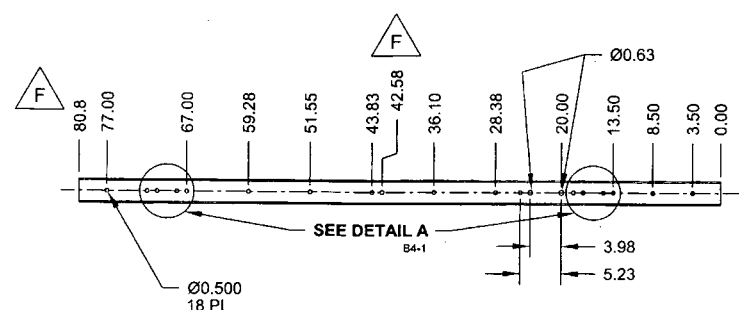
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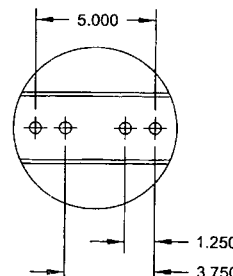
**NOTE:** Date & initial all entries



**D2654-1 WEB**



**D2654-3 WEB**



**DETAIL A**

**RELEASED**  
2011-09-12

**NOTES:**

- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs  
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

NO. 78832 M.C.J.  
12/01/18

DESIGN	CP	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	90	DRAWING NO.	REV. F
MFG. APPR.	BE	D2654	SHEET 1 OF 2
APPROVED	140	TITLE	SCALE
DE APPR.	140	WEB	NTS
DATE	11.05.05	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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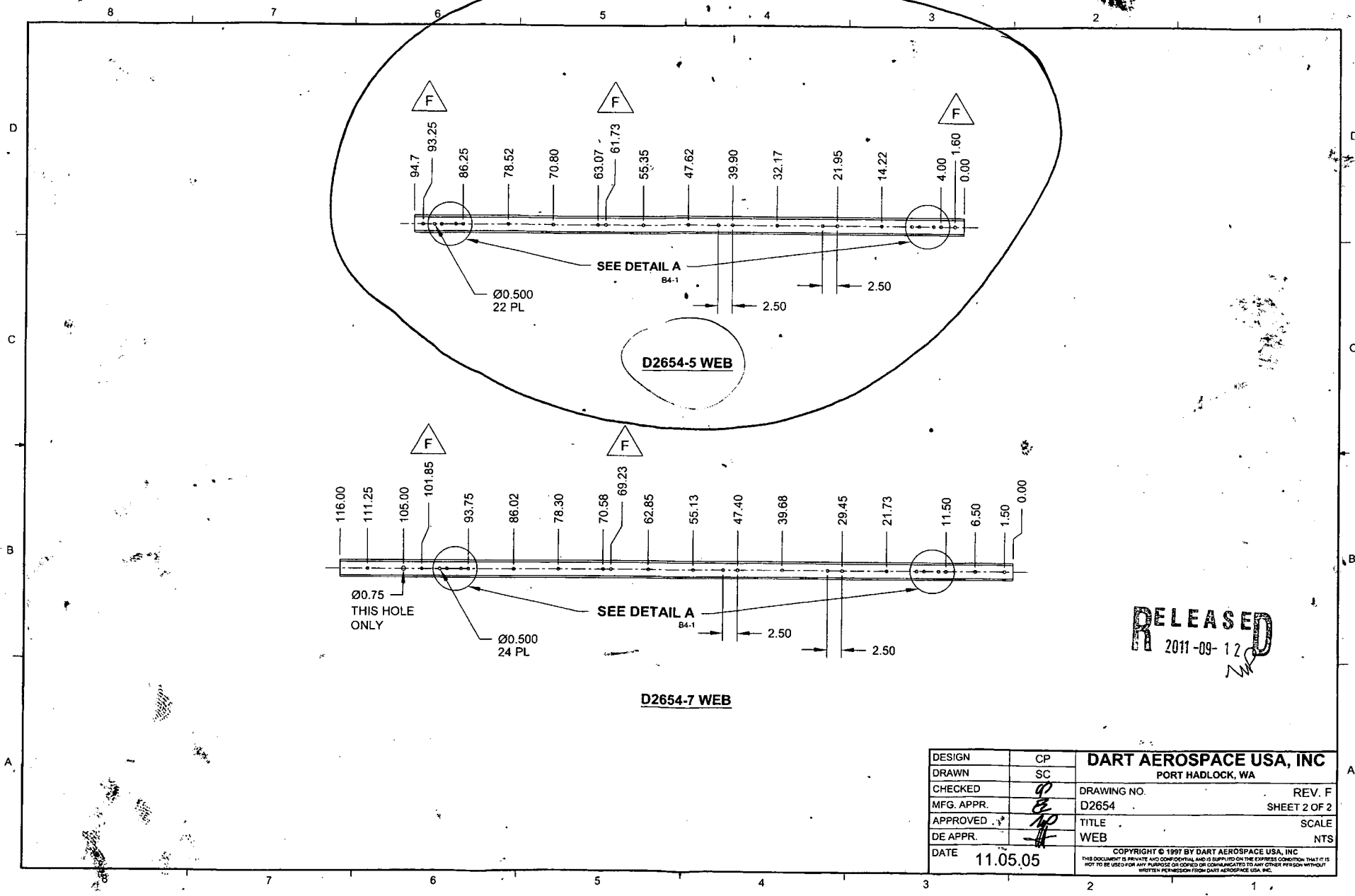
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DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2654	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEB	NTS
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